



Dart Aerospace Ltd.
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D3849-043

Job Sheet 204082



POSITIVE RECALL

Part No: D3849-043

Job Qty: 12 pcs

EFFECTIVE ~~_____~~ AUTH ~~_____~~

Part Name: Aft Heavy-Duty Wearplate, Std Skid Compatible

RELEASED ~~_____~~ DATE ~~_____~~

Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/2/19

Job Tracking No:

Due Date: 12/18/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: URF 19-902 D3849 REV.G IPP RevA: New issue DD verified by:EC IPP Rev:B 12.09.11 AS PER DWG REV.D
DD VERF:JLM IPP Rev:C 14.11.26 AS PER DWG REV.E DD VERF:JLM IPP REV:D 16.06.17 DWG REV.F
DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Large Fab - Welded Assy-1	12 pcs	12/18/19		0.00	30.00	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
120	QC 9	12 pcs	12/18/19		0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
130	QC 5	12 pcs	12/18/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		



Dart Aeros
1270 Aberdeen
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TEL: 1 813 6
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Container No: S247731



a D3849 - 043

Job No: 204082

Serial No/Batch: S247731

Revision: REV.G

Operator:

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						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	12
						QC 5 - 30	
						QC 5 - 40	
						QC 5 - 61	
						QC 5 - 81	
140	Spray Paint - 2 - B4B	12 pcs	12/18/19	0.00	3.00	Spray Paint - 1 - B4B	
						Spray Paint - 2 - B4B	
						Spray Paint - 3 - B4B	RD 20-1-15
						Spray Paint - 4 - B4B	
150	QC 5	12 pcs	12/18/19	0.00	0.00	QC 5 - 10	
						QC 5 - 12	
						QC 5 - 17	
						QC 5 - 18	
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	JAN 16 2020 68
						QC 5 - 9	9-89
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
						QC 5 - 61	
						QC 5 - 81	
160	Packaging 3-1 - Stock - B4B	12 pcs	12/18/19	0.00	0.00	Packaging 3 - 1 - B4B	FP-602 20-1-16
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	
						Packaging 3 - 20 - B4B	
						Packaging 3 - 21 - B4B	
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						Packaging 3 - 25 - B4B	
						Packaging 3 - 26 - B4B	
						Packaging 3 - 27 - B4B	
						Packaging 3 - 28 - B4B	

					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
170 QC 21 - SA	12 pcs	12/18/19	0.00 0.00		QC 21 - SA - 21	
					QC 21 - SA - 70	DAS
					QC 21 - SA - 53	21

Part Op 110 - (Weld per dwg A/R S.S. rod Batch: M136585) 1- Weld D3901-043 bar to wearplate as per dwg D3849
 Descriptions: TRANSFER DRILL 00.188 HOLES FROM D3849-3 WEARPLATE TO D3901-041 WEARBARS,
 120 - (QC9- Inspect visual per QSI004- Fusion Welds)
 130 - (QC5- Inspect part completeness to step on W/O)
 140 - 1- Apply a layer of TEXTURE COATING as per dwg Batch: M136585 \$ 242921
 150 - (QC5- Inspect part completeness to step on W/O)
 160 - (Identify as per dwg & Stock Location: _____) LOCATION : FG002
 170 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D3849-3	Plate	12 pcs (1 ea)	110-Large Fab - Welded Assy-1	5240532
D3901-043	Wearbar Weldment	24 pcs (2 ea)	110-Large Fab - Welded Assy-1	5237910

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Welded Assy-1	D3849-3	12	0	0
	D3901-043	24	0	0

Part Specifications	
Specifications could not be found.	

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Entered: _____ Date: _____

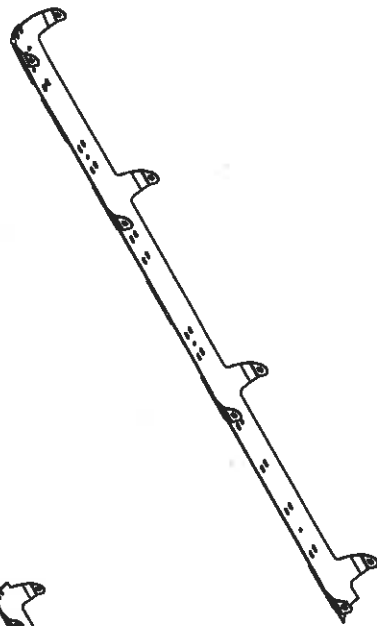
WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

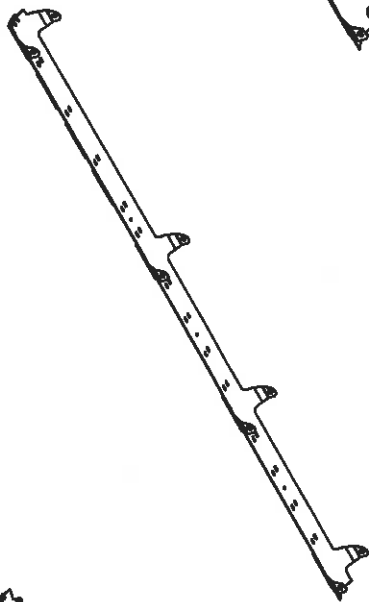
Route update only ☐

Job: _____ Part No. _____		DISPOSITION ☐ Rework ☐ Scrap ☐ Use-as-is ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality				DEPARTMENT/PROCESS				MRB (QS1042)	
Date : _____		Sequence #: _____		QTY Affected : _____		Disposition					
Description Work Order Deviation		Completed By									
_____		Lead hand / Supervisor									
_____		QC / QA Coordinator									

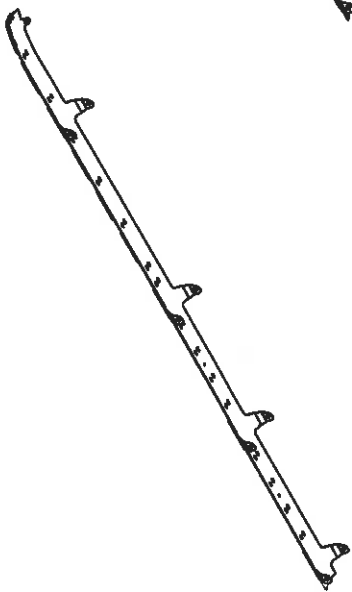
Root Cause ☐ Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		FAULT CATEGORY		Other/Details:		
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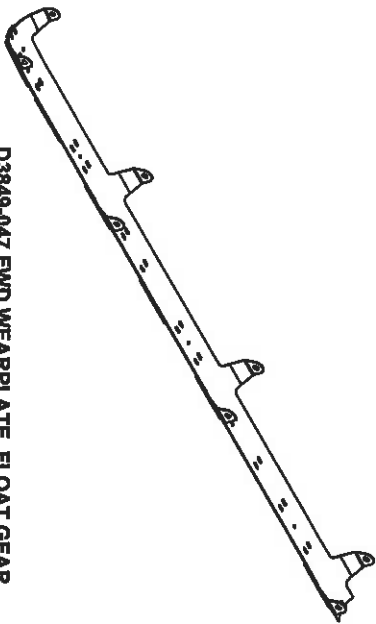
D3849-041 FWD WEARPLATE ASSY, STD GEAR



D3849-043 AFT WEARPLATE ASSY, STD GEAR



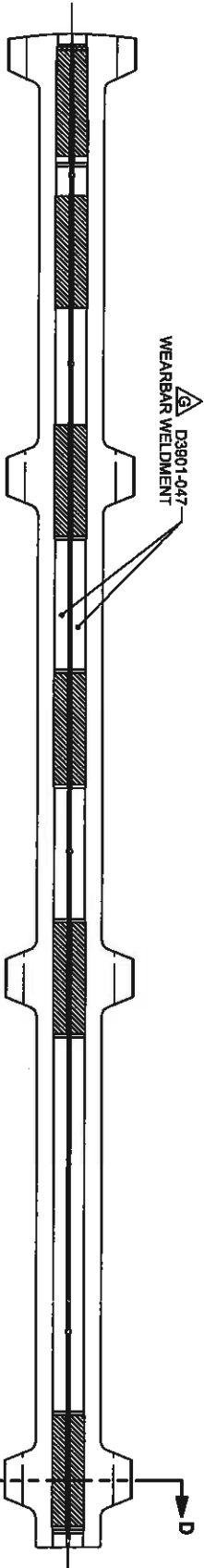
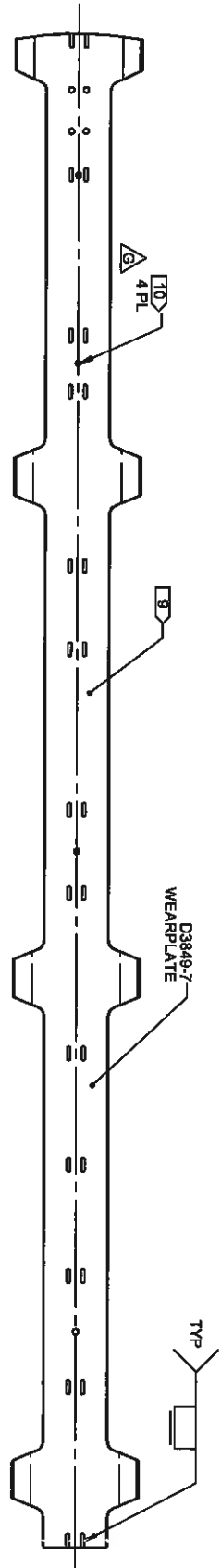
D3849-045 AFT WEARPLATE ASSY, FLOAT GEAR



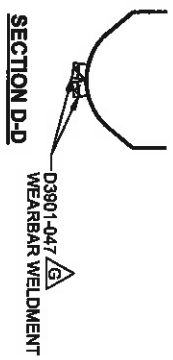
D3849-047 FWD WEARPLATE, FLOAT GEAR

[illegible]

QTY	PN	DESCRIPTION
447		
X	D3849-047	FWD WEARPLATE, FLOAT GEAR
1	D3849-7	WEARPLATE
2	D3901-047	WEARBAR WELDMENT



D3849-047 FWD WEARPLATE, FLOAT GEAR



- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY PER OSI 044 6.1
 - 7) WEIGHT: 7.45lbs
 - 8) WELDING: PER OSI 004
 - 9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK, PER DART OSI 005 4.9.
 - 10) TRANSFER DRILL Ø0.186 HOLES FROM D3849-7 WEARPLATE TO D3901-047 WEARBARS, AFTER APPLYING TEXTURED COATING

RELEASED

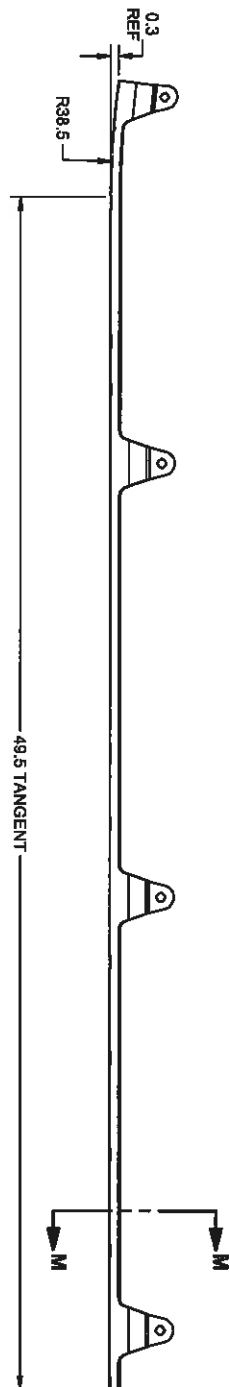
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DRAWN	ZF	HILLSBORO, OR
CHECKED	MM	
MFG. APPR.	DD	
APPROVED	NO	
DE APPR.	DS	
DATE	19.06.11	
		WEARPLATE ASSY
		SCALE NTS

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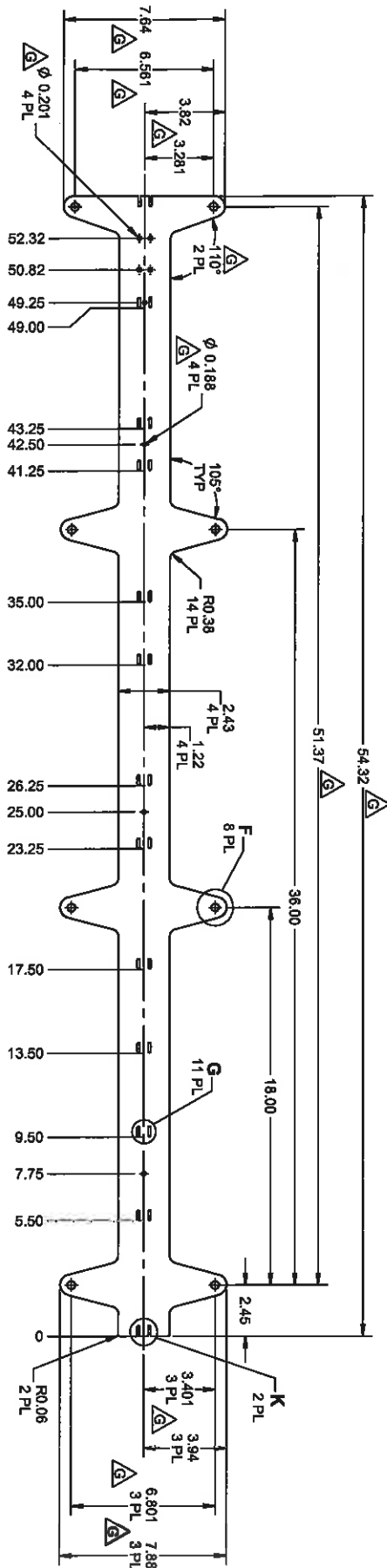


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DESIGN	RF	
DRAWN	ZF	
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MFG. APRL	DD	
APPROVED	NO	
DE APRL	DS	
DATE	19.06.11	
WEARPLATE ASSY		TITLE
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D3849-7 WEARPLATE
(MAKE FROM D3849-7F)



D3849-7F FLAT PATTERN

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 18 GAUGE (0.060 THICK)
PER MIL-S-5068 OR AMS 5613 OR 5624
OR ASTM A240 OR ASME SA240
REF: DART SPEC. M304S18GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.006 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 2.28 lbs

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MFG. APPR.	DD	D3849
APPROVED	NO	REV. G
DE APPR.	DS	WEARPLATE ASSY
DATE	19.06.11	SHEET 8 OF 10
		SCALE
		NTS

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